

Work Order ID 129650

129650

Page 1

February-23-15 10:14:02 AM

Item ID: D2126

Revision ID:

Item Name: Seal

Start Date: 2/23/15

Start Qty: 50.00

Required Date: 2/23/15

Req'd Qty: 50.00

Reference:

Accept

500 CD 15/02/27

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: MLS

Date: 15-02-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2126	Rev C								

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O:

Make per Dwg D2126

Possible Supplier: Accurate Rubber: P/N: 110750004

Material release note required

ACR.

MLS

15-02-27

500

110

0.00

110

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Packaging

Ensure material certification is attached

500x 8015-03-30

120

0.00

120

QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

500

DAS
38
9-89

MAR 31 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 129650

February-23-15 10:14:02 AM

129650

Page 2

Item ID: D2126 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Seal
 Start Date: 2/23/15 Start Qty: 50.00 *50* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 50.00 *50* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST 414</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
MAR 3 1 2015

MS 15-04-01

MS.4-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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Picklist Print

February-23-15 10:14:01 AM

Page 1

Work Order ID: 129650

1 29650

Parent Item: D2126

D2126

Parent Item Name: Seal

Start Date: 2/23/15**Required Date:** 2/23/15

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev: B99.03.29Re-format, ECN 175 (Dwg to Rev. C)DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
110750004		Purchased	No			110	Each	0.0000	1	500			
110750004 Seal									**	500X 8/15-03-30			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Doc/Data									
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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other



RELEASED
99.03.15 KE

STOCK COPY
FOR PARTS
TO COPY
COMMENT
DATE

129650.MLS
1502-23

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED KE	DRAWING NO. D2126
DATE 99.03.15	TITLE LOCKING SEAL	SHEET 1 OF 1
A	92.03.16	NEW ISSUE
B	98.12.01	REDRAWN: ADD PATTERN
C	99.03.15	ADDED COMPLETE DIMENSIONS, REMOVED REFERENCE TO OTHER SUPPLIERS



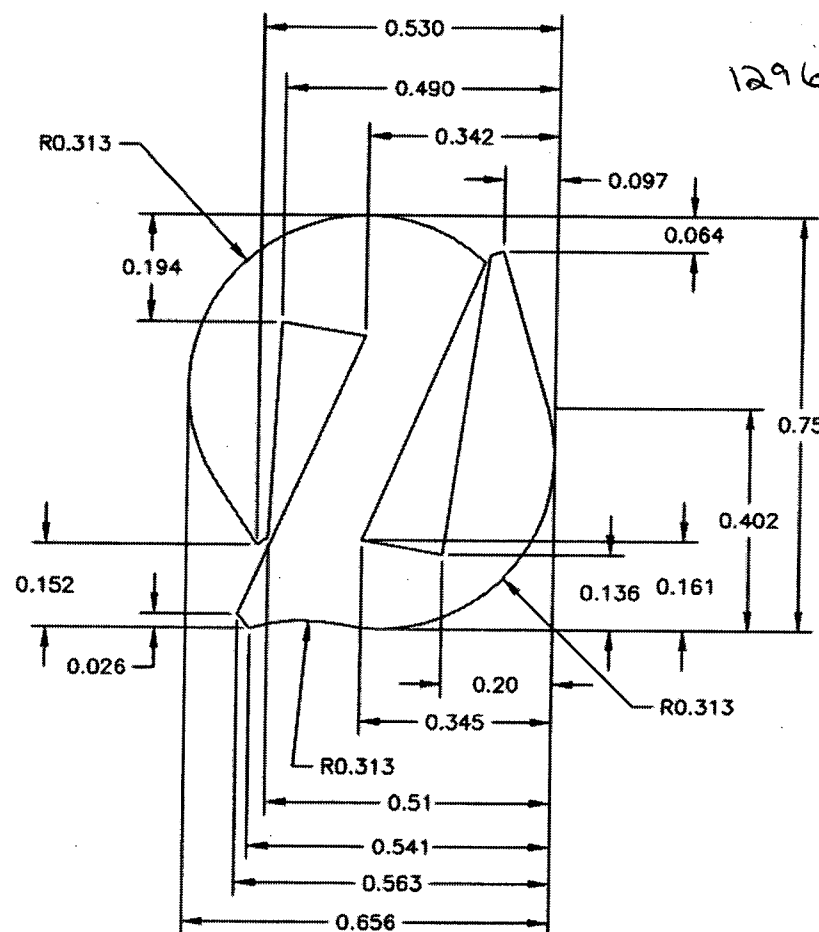
1:1 SCALE
DETAIL

D2126-XXXX LOCKING SEAL
LENGTH

EG: 87.5" LONG: D2126-0875
10" LONG: D2126-0100

POSSIBLE SUPPLIERS:

ACCURATE RUBBER
ITEM NUMBER 110750004
PER DIE NUMBER 631



NOTES:

MATERIAL: 85 DUROMETER NATURAL RUBBER/SBR
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27596**

Purchase Order Date 2/27/2015

PO Print Date 2/27/2015

Page Number 1 of 2

Order From :

VC-ACR001

ACR GROUP INC.
12771 - NO. 5 ROAD
RICHMOND, BC V7A 4E9
CA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 604 274 9955

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	110750004 AS PER DWG.D2126 REV.C B129650	Seal	3/30/2015 Yes 3/30/2015		500.00 Each	\$3.50	\$1,750.00
Line Total:							\$1,750.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	3/30/2015 No 3/30/2015		1.00	\$0.00	\$0.00
Procurement Quality Clauses							
A004 faa-pma/tso							
A005 right of entry							
A015 shelf life controlled material 60%							
A016 personnel qualification							
A017 raw material identification							
A026 certification of material conformance							
A041 Quality management system							
A043 retention of quality documents							

PO Instructions: Fedex Acc#151793240

Note:

2/27/2015



www.acrgroup.ca

12771 No. 5 Road
Richmond, B.C.
Canada V7A 4E9

Tel: 604-274-9955
Fax: 604-274-1013
Toll Free: 1-888-478-2237

PACKING SLIP

CUSTOMER COPY

PACKING SLIP 00153399

CUSTOMER NO. 10750

PST#

S
O
L
D
T
O
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

S
H
I
P
T
O
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

DATE		SHIP VIA		TERMS	
03/27/15		FED EX 0/N		ACR GROUP INC. NET 30 DAYS	
PURCHASE ORDER NUMBER		DATE ORDERED		SALES PERSON	
P027596		02/27/15		00153399 ROB	
QUANTITY		ITEM NUMBER		DESCRIPTION	
ORDERED	SHIPPED	B.C.			
500	500	✓	110750004	#YAD-2126 LOCKING SEAL EXTRUSION	FT
			2 cartons - 24" x 24" x 8" - 50 lbs ea.		
			SP 5-03-30		
			SUBTOTAL HST		
			TOTAL AMOUNT		
FREIGHT: Collect					

Quality Rubber Products To Your Requirements
Specialists in Bonding Natural and Synthetic Rubber To Metal
Molded and Extruded Rubber Products, Cast Polyurethane Specialties